

Work Order ID 113500

February-19-14 9:12:01 AM

113500

Page 1

Item ID: D206-642-511 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube LH, High Gear Apical Tri-Bag Float Compatible
 Start Date: 2/19/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 2/19/14 Req'd Qty: 1.00 *1* Customer:
 Reference: rework - damaged

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
INN-D206-642	P

100 0.00
 100 DOCUMENT CONTROL
 DC Memo 0.00
 Doc.Control -USB or Paperwork Photocopy bluefile and create labels per PPP D206-642-511 CHG005

101 0.00
 101 HandFinish 0.00
 Hand Finishing
 Memo
 PULL :
 1 X D206-642-511 B111919
 DAMAGED IN TRANSPORT TO MTL FOR OFFSHORE
 REMOVE AFT CAP, DISCARD.
 REPLACE WITH NEW AFT CAP
 1 X D2646 B 110816
 2 X NAS1149C0332R B M 12783
 2 X AN3C4A B M 12783
 2 X NAS1515H3L B M 12783
 SIKAFLEX B M 127918 1/169
 TOUCH UP FWD END A/R

PATENT		1270 ABERDEEN ST HAWKESBURY ON CANADA K6A 4K7 TEL: 613-662-5200 www.dartbarco.com	
P/N	D206-642-511	CHG	CHG005
DESC	Float Skidtube LH	STC	SH98-4
LOT	B111919	STC	SA00475SE
MODEL	206L/L1/L3/L4/407	STC	
TC APPROVAL # 09-69		MADE IN CANADA	

1 x 1 f 11 11/02/24

Work Order ID 113500

February-19-14 9:12:01 AM

113500

Page 2

Item ID: D206-642-511 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube LH, High Gear Apical Tri-Bag Float Compatible
 Start Date: 2/19/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 2/19/14 Req'd Qty: 1.00 *1* Customer:
 Reference: rework - damaged

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
103	QC5- Inspect part completeness to step on W/O	0.00							
103									
QC	Memo	0.00							
Quality Control									
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging	ENSURE ORIGINAL KIT IS IN BOX								
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

Handwritten signature and date 14-02-24

Handwritten: 16073

Handwritten: 14-226

Handwritten: DAS 6 9-89 28 9-89

Handwritten: 14-226

Handwritten: DAS 6 9-89

Handwritten: 14-02-27

Handwritten: 14-02-27

Work Order ID 113500

February-19-14 9:12:01 AM

113500

Page 3

Item ID: D206-642-511

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH, High Gear Apical Tri-Bag Float Compatible

Start Date: 2/19/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/19/14 Req'd Qty: 1.00 ***1***

Customer:

Reference: rework - damaged

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Packaging

Packaging

Memo

0.00

ND

DAS
6
9-89

14-2-26

Packaging

REPACKAGE PER PPP USING NEW B/N
Identify and pack for shipping as per PPP D206-642-511
Location: _____

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

Bring to binder
need to change
transport for
damage

PL 14-02-27
14.02-27

February-19-14 9:12:00 AM

113500

D206-642-511

Required Date: 2/19/14

Required Qty: 1.00

Comments: IPP Rev:B05.09.23Revised per D206-642 Rev. KJ/JLM
 IPP Rev:C 07-02-23 As per IIN D206-642 Rev K JLM
 IPP rev D 07.06.06 added K642-511 EC
 IPP Rev:E 07-12-05 ECN 1080p Rev L DD verified by: IPP REV:F
 13.09.06 CHG005/ECN13-634 DD VVERF:JLM

[illegible]

AN3C4A

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	20	
122814	20	
ST512	3	
124221	3	
ST513	2270	
125388	1835	
M127410	29	
M127832	406	

Picklist Print

February-19-14 9:12:00 AM

Page 2

Work Order ID: 113500

113500

Parent Item: D206-642-511

D206-642-511

Parent Item Name: Skidtube LH, High Gear Apical Tri-Bag Float Compatible

Start Date: 2/19/14

Required Date: 2/19/14

Start Qty: 1.00

Required Qty: 1.00

D206-642-511

Manufactured No

Each

10.0000

1

D206-642-511

Skidtube LH, High Gear Apical Tri-Bag Float Compatible

ll 14/02/14

Location

Loc Qty

Loc Code

FG

8

B111919

xl

105640

1

106462

1

106987

1

109870

1

111668

1

83034

1

89627

1

98615

1

FG073

2

107849

1

109645

1

109870

0

D2646

Manufactured No

Each

66.0000

1

D2646

Aft Cap

ll 14/02/14

Location

Loc Qty

Loc Code

FG

4

85848

2

90495

2

FP001

62

103306

18

107857

1

110816

43

xl

Picklist Print

February-19-14 9:12:00 AM

Page 3

Work Order ID: 113500

113500

Parent Item: D206-642-511

D206-642-511

Parent Item Name: Skidtube LH, High Gear Apical Tri-Bag Float Compatible

Start Date: 2/19/14

Required Date: 2/19/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

Each

9,046.000

2

NAS1149C0332R

**

WASHER

Location

Loc Qty

Loc Code

GA

1157

125654

1157

st510

7889

m126319

369

m127306

2500

m127410

3000

m127831

2020

x 2

NAS1515H3L

Purchased

No

Each

432.0000

2

***NAS1515H3L ***

**

Washer

Location

Loc Qty

Loc Code

FG

32

102472

32

ST297

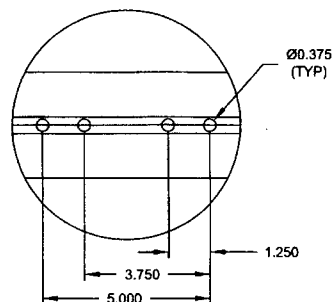
400

m127831

400

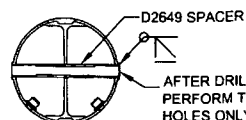
x 2

DETAIL A: DRILL DETAIL
D6-2, D3-2, D5-3, D3-3



DETAIL B
B6-2, B5-3

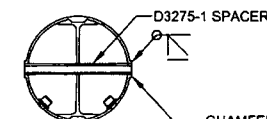
FOR Ø0.375 HOLES ONLY



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO Ø0.313x0.75 DEEP

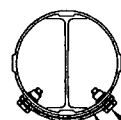
DETAIL C
B5-2, B4-3

FOR Ø0.313 HOLES ONLY



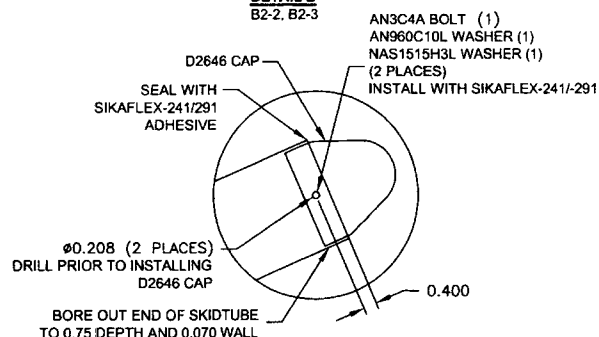
CHAMFER 0.030x45°
(TYP)

DETAIL D
A4-2, A4-3

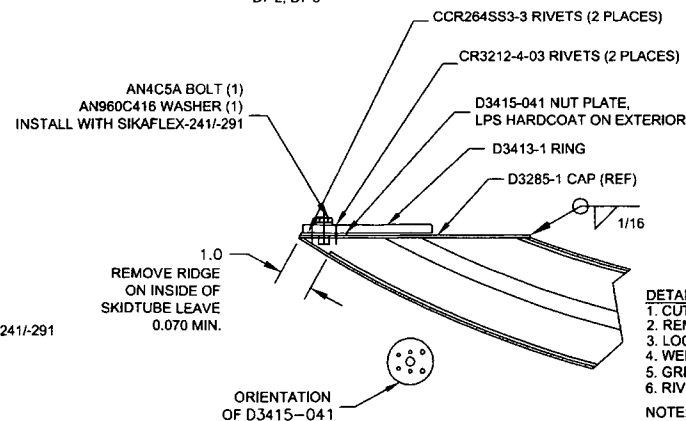


ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)
GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E
B2-2, B2-3



DETAIL F: END FINISHING DETAIL
B7-2, B7-3



DETAIL F NOTES
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE
NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

RELEASED
9/13/14

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	DW	KENT, WA	
CHECKED	AP	DRAWING NO.	REV. E
MFG. APPR.	DD	D3274	SHEET 4 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
DATE	13.05.17	COPYRIGHT © 2004 BY DART AEROSPACE USA, LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, LTD.	

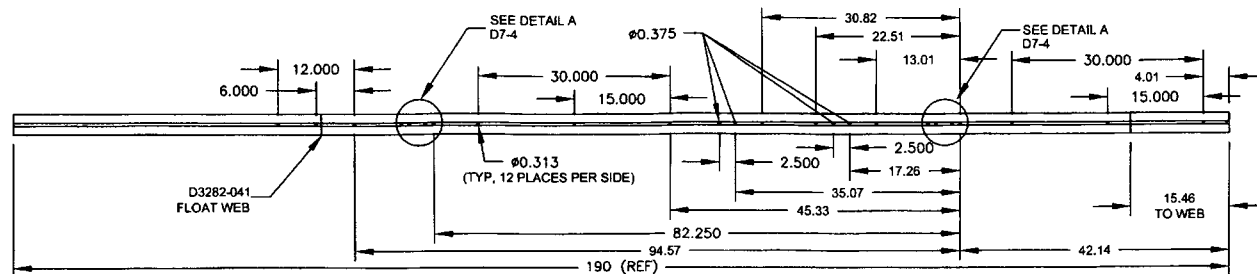
Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN860C416	WASHER
80	80	AN860C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

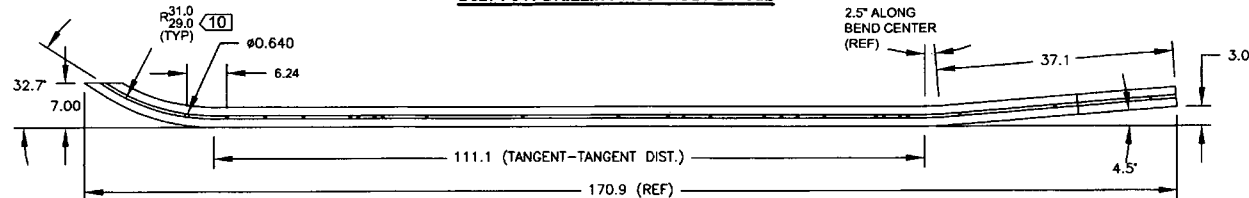
- MATERIAL: N/A
- FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2 E
- TOLERANCES ARE PER DART QSI 016 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES 0.005 TO 0.010 MAX
- IDENTIFICATION: N/A
- WEIGHT: 20.8 LBS
- WELDING TO BE DONE PER DART QSI 004.
- ALL HOLES DRILLED ON CENTERLINES.
- DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
- DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX-241/-291.
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS GREASE WITH WASH 'N WIPE DEGREASER.

RELEASED
9/13/14
EKN 19-567

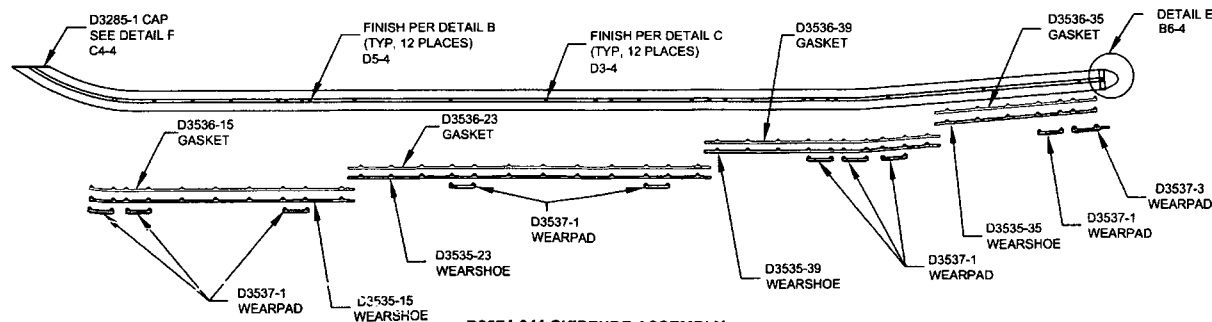
E	REVISE NOTE 2: FINISH NOW PRIME/PAINT WAS POWDERCOAT, REF. PAR13-256	DW	13.05.17
D	NEW INSERTS, SS WEARSHOE + GASKET	CP	06.12.19
C	ADD -043; NEW INSERTS	CP	05.03.16
B	MOVE SADDLE HOLE: 42.14 WAS 42.76	CP	04.08.09
A	NEW ISSUE	CP	04.03.15
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD KENT, WA	
DRAWN	DW		
CHECKED	AP	DRAWING NO.	REV. E
MFG. APPR.	DD	D3274	SHEET 1 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
DATE	13.05.17	<small>COPYRIGHT © 2004 BY DART AEROSPACE USA, LTD. THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, LTD.</small>	



D3274-041 DRILLING/ASSEMBLY DETAIL



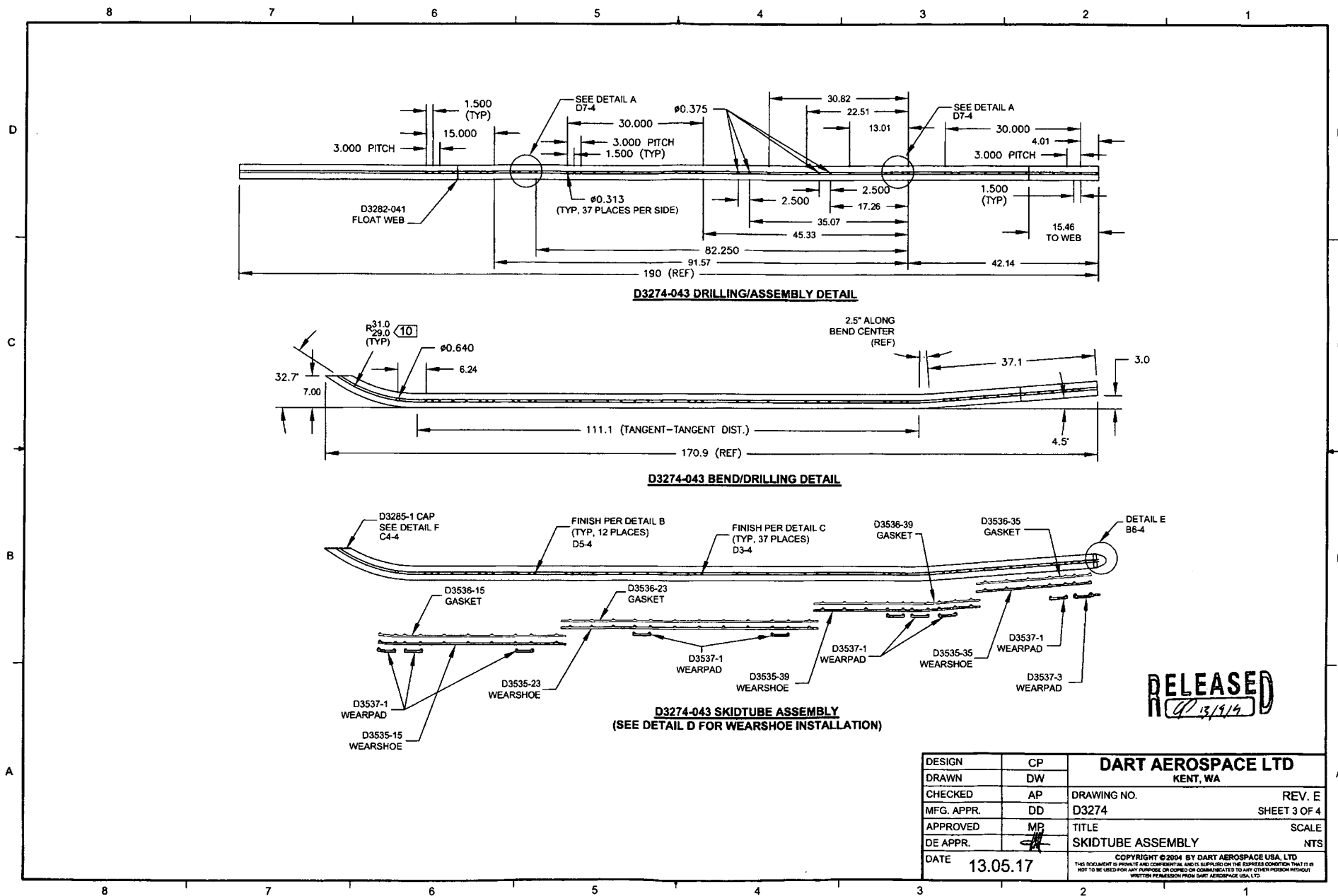
D3274-041 BEND/DRILLING DETAIL



**D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)**

RELEASED
47 3/9/14

DESIGN	CP	DART AEROSPACE LTD KENT, WA	
DRAWN	DW		
CHECKED	AP	DRAWING NO.	REV. E
MFG. APPR.	DD	D3274	SHEET 2 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
DATE	13.05.17	<small>COPYRIGHT © 2004 BY DART AEROSPACE USA, LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, LTD.</small>	



RECEIVED

Linda Lacelle

From: Brigitte Golden
Sent: February-18-14 2:40 PM
To: Brad Easterbrook
Cc: Linda Lacelle; Alex Smith
Subject: DAMAGE SKIDTUBE

Brad,
The skidtube is repairable, and we will let you know of the cost once the w/o for the repair is complete.
Thank You
Brigitte

From: Linda Lacelle
Sent: Tuesday, February 18, 2014 1:32 PM
To: Sylvain Boyer
Cc: Brigitte Golden
Subject: FW: quote please

Pls let us know if the tube is repairable

From: Brigitte Golden
Sent: February-18-14 1:27 PM
To: Brad Easterbrook
Cc: Linda Lacelle; Alex Smith
Subject: RE: quote please

Yes it is repairable, but the cost, Linda will have to give you a\$\$\$
TX

From: Brad Easterbrook [<mailto:BEasterbrook@JourneyFreight.com>]
Sent: Tuesday, February 18, 2014 1:25 PM
To: Brigitte Golden
Cc: Linda Lacelle; Alex Smith
Subject: RE: quote please


Hello,

We will have to fill out a claim form..I will send you some info asap.. Is the tube repairable? If so do you know the cost?



TRANSPORT EXPRESS MINIMAX TRANSPORTATION INC.
P.O. BOX 92, CORNWALL, ONTARIO K6H 5R9
1-800-465-6657

DELIVERY RECEIPT
REÇU DE LIVRAISON

DATE 02-14-2014	TRAILER - REMORQUE	ORIG. DRM	DEST. COR	NIR R-519336	CVOR 3104-372-613	PRO. 1097096
SHIPPER / EXPÉDITEUR JOURNEY FREIGHT 18100 TRANSCANADA KIRKLAND, QC H9J 4A1 (514) 344-2202			CONSIGNEE / CONSIGNATAIRE DART AEROSPACE 1270 ABERDEEN ST HAWKESBURY, ON K1A 1K7 (613) 632-5200			CODE 53  GST / TPS: R 126922954 QST / TVQ: 1010859073
JCT	ORIG. CARRIER / REÇU DE PRO			JCT	TRANSFER TO / TRANSFERT À	
PCS 1 PCS	TYPE	DESCRIPTION STC 1 BOX HELICOPTER PARTS			WEIGHT / POIDS 70L	B/L PC20015537
TOTAL 1					DECLARED VALUE / VALEUR DÉCLARÉE 0	
DRIVER / CHAUFFEUR K		DATE 2-18-14		TOTAL 70L		
PCS 312/207		UNIT / INTÉRIEUR		OUT / SORTIE		
CPC		RETURN		C.O.D. C.R.		
C.O.D. FEE FRAIS DE C.R.		TOTAL ▶				

ANY LOSS OR DAMAGE MUST BE NOTED ON PROBILL AT TIME OF DELIVERY.
TOUTES PERTES OU DOMMAGES DOIVENT ÊTRE SIGNALÉES AU MOMENT DE LA LIVRAISON.

BILL TO:
JOURNEY FREIGHT
18100 TRANSCANADA
KIRKLAND, QC



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada
Tel.: 1.613.632.5200
Fax: 1.613.632.1185
GST # RT101272607

**Commercial Invoice: 285**

Ship From: Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON
K6A 1K7
Canada
GST#: RT101272607
TEL: 1.613.632.5200

Ship To: Offshore Helicopter Support Services
200 A Burgess Drive
Broussard, LA 70518
USA
attn: Tad Kling
IRS#: 721413256
TEL: 337 829 0500

Date: 12-Feb-14
Ship Via: Journey Freight
Reference: WAREHOUSE TRANSFER
Country of Origin: CANADA

P.O. #: N/A
BROKER: UPS SCS PPD PREPAID

Item ID	Item Name	Tariff Class.	Lot Qty	Unit Avg Cost	Total Amt
D139-799-025	Cargo Compartment	8803.3	2	\$346.00	\$692.00
D206-781-061	Baggage protector	8803.3	2	\$223.00	\$446.00
D206-628-011	Heli-Access Step	8803.3	1	\$537.00	\$537.00
D206-628-012	Heli Access Step	8803.3	1	\$442.00	\$442.00
D350-591-312	Access Step	8803.3	1	\$530.00	\$530.00
D350-636-215	Skidtube	8803.2	1	\$2,980.00	\$2,980.00
D206-642-511	Skidtube	8803.2	2	\$3,529.00	\$7,058.00
D2230-3	Lug	8205.7	4	\$12.00	\$48.00
D3552-23	Door Prop	8803.3	2	\$32.00	\$64.00

ALL PRICE ARE IN USD

TOTAL: \$12,797.00

NMFC# 12190 Class 200

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada
Tel.: 1.613.632.5200
Fax: 1.613.632.1185
GST # RT101272607

**Dart Aerospace Ltd.**

1270 Aberdeen Street
Canada
Tel # 1.613.632.5200
GST # RT101272607

Offshore Helicopter

200 A Burgess Drive
Broussard, LA , 70518

Tad Kling
337 829 0500

Date: JAN 17TH 2014

P.O. #: N/A

Ship Via: Journey

Item ID	Item Name	Lot Nbr	QTY
D139-799-025	Cargo Compartment	B108228	2
D206-781-061	Baggage protector	B112631	2
D206-628-011	Heli-Access Step	B104542	1
D206-628-012	Heli Access Step	B93907	1
D350-591-312	Access Step	B112718	1
D350-636-215	Skidtube	B106955	1
D206-642-511	Skidtube	B111668	2
D2230-3	Lug	B109334	4
D3552-23	Door Prop	B107728	2

Work Order ID 113500

113500

All

February-19-14 9:12:01 AM

Item ID: D206-642-511 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Skidtube LH, High Gear Apical Tri-Bag Float Compatible

Start Date: 2/19/14 Start Qty: 1.00 *1*

Required Date: 2/19/14 Req'd Qty: 1.00 *1*

Reference: rework - damaged

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
INN-D206-642	P

100

DOCUMENT CONTROL

100

DC

Doc.Control -USB or Paperwork

Memo

Photocopy bluefile and create labels per PPP D206-642-511 CHG005

0.00

0.00

SP

101

101

HandFinish

Hand Finishing

Memo

PULL:

1 X D206-642-511 B111919
 DAMAGED IN TRANSPORT TO MTL FOR OFFSHORE
 REMOVE AFT CAP, DISCARD.
 REPLACE WITH NEW AFT CAP
 1 X D2646 B 40816
 2 X NAS1149C0332R B M12783
 2 X AN3C4A B M127832
 2 X NAS1515H3L B M127831
 SIKAFLEX B M127918 1/109

TOUCH UP FWD END A/R

0.00

0.00

MLJ 14-02-26

DART AEROSPACE		1270 ABERDEEN ST. HAWKESBURY, ON CANADA K6A 1K7 TEL.: 1-613-632-5200 www.dartaerospace.com	
PATENT			
P/N	D206-642-511	CHG	CHG005
DESC.	Float Skidtube LH	STC	SH98-4
LOT	B111919	STC	SA00475SE
MODEL	206L/L1/L3/L4/407	STC	
TC APPROVAL # 09-89		MADE IN CANADA	
		D2729-4	

1 - 1 - 1 - 1/02/24

